

Work Order ID 105017

July-03-14 10:02:49 AM

105017

Reprint

Page 1

Item ID: D4785-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 7/18/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/23/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-07-03 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4785	B								

100 Weld per dwg A/R S.S. rod Batch: 14123823 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- Use DT9610A to assemble contour ribs and the (2) D3916-5 ribs , weld as per
 dwg D4785

inspect before welding mesh

2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D4785 ✓
 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends

3- weld hinge (3) and Mounting brackets as per dwg D4785 ✓
 take lid to locate hinge and bracket

4- Weld D4672-1 blanking plates as per dwg ✓

1y DAS
 43
 9-89 14-7-15

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

D 14-07-16 DAS
 9
 9-89

Work Order ID 105017

July-03-14 10:02:49 AM

105017

Page 2

Item ID: D4785-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9.00
120									
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.00							
Hand Finishing									

D 14-07-16
1 14-07-20 CR

Work Order ID 105017

July-03-14 10:02:49 AM

105017

Page 3

Item ID: D4785-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 10:50

OVEN TEMPERATURE: 400°

FINISH TIME: 11:50

***** 2nd coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

1 0 14721 DAS 15 9-89

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 0 14721 DAS 15 9-89

Work Order ID 105017

July-03-14 10:02:49 AM

105017

Page 4

Item ID: D4785-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Base Assembly, LH/RH
 Start Date: 7/18/13 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/23/13 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing	Pick kit and assemble								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

DAS
15
9-89

DAS
27
9-89
14/7/21

04784-011 / B121884

14 4 14/02/21

14 4 14/07/21

Work Order ID 105017

July-03-14 10:02:49 AM

105017

Page 5

Item ID: D4785-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/23/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

14/7/22 JG

Picklist Print

July-03-14 10:02:51 AM

Page 1

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.14 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.17 as per dwg rev.pb1 DD VERF:JLM IPP REV:C
13.07.04 revise bom per dwg rev.B DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4785-1		Manufactured	No			100	Each	4.0000	2	2			
D4785-1													
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
				121280				4					
D4785-5		Manufactured	No			100	Each	6.0000	3	3			
D4785-5													
Rib													
				<u>Location</u>				<u>Loc Qty</u>					
				WA				6					
				109292				6					
D4785-115		Manufactured	No			100	Each	2.0000	4	4			
D4785-115													
Rib Assembly													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				2					
				116173				2					
D4785-117		Manufactured	No			100	Each	0.0000	2	2			
D4785-117													
Rib Assembly													
				<u>Location</u>				<u>Loc Qty</u>					
				FG				2					
				116173				2					

**

B121280 → 2x

DAS
43
9-89

14.7.8

**

B109292 → 3x

DAS
43
9-89

14.7.8

**

B117625 → 4x

DAS
43
9-89

14.7.8

**

B121280 → 2x

DAS
43
9-89

14.7.8

Picklist Print

July-03-14 10:02:51 AM

Page 2

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

D4785-3 Manufactured No

100 Each 4.0000 2 2

DAS

D4785-3

**

B121283 → 2x 43 14.7.8
9-89

Rib

Location

Loc Qty

Loc Code

WA004

4

121283

4

D4017-7 Manufactured No

100 Each 13.0000 3 3

DAS

D4017-7

**

B116023 → 3x 43 14.7.8
9-89

Rib

Location

Loc Qty

Loc Code

WA004

13

116023

13

D4034-041 Manufactured No

100 Each 3.0000 1 1

DAS

D4034-041

**

B121760 43 14.7.8
9-89

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA004

3

116787

2

118856

1

D4034-043 Manufactured No

100 Each 4.0000 1 1

DAS

D4034-043

**

B121513 43 14.7.8
9-89

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA004

4

115432

1

116765

2

119352

1

July-03-14 10:02:52 AM

Shop Packet Print

Page 2

Picklist Print

July-03-14 10:02:52 AM

Page 3

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

D3916-5	Manufactured	No	100	Each	6.0000	2	2	DAS 43 9-89
D3916-5								14-7-8
Light Rib								

Location

Loc Qty

Loc Code

WA004

6

115090

3

119550

3

D3913-1	Manufactured	No	100	Each	2.0000	1	1	DAS 43 9-89
D3913-1								14-7-8
Rib								

Location

Loc Qty

Loc Code

WA004

2

115813

1

116328

1

D3913-3	Manufactured	No	100	Each	3.0000	1	1	DAS 43 9-89
D3913-3								14-7-8
Rib								

Location

Loc Qty

Loc Code

WA004

3

115798

3

D3913-9	Manufactured	No	100	Each	5.0000	1	1	DAS 43 9-89
D3913-9								14-7-8
Hinge Rib								

Location

Loc Qty

Loc Code

WA004

5

115610

4

115611

1

July-03-14 10:02:52 AM

Shop Packet Print

Page 3

Picklist Print

July-03-14 10:02:52 AM

Page 4

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

D4793-1

Manufactured No

100

Each

2.0000

3

3

DAS
43
9-89

D4793-1

Handle Plate

**

B 121285 → 2x 14-7-8

B 119401

Location

Loc Qty

Loc Code

WA004

2

121285

2

D4793-3

Manufactured No

100

Each

3.0000

1

1

DAS
43
9-89

D4793-3

Handle Plate, Wide

**

B 121286 14-7-8

Location

Loc Qty

Loc Code

WA004

3

121286

3

D4672-1

Manufactured No

150

Each

1.0000

2

2

DAS
43
9-89

D4672-1

Blanking Plate

**

B 116832 → 2x 14-7-8

Location

Loc Qty

Loc Code

WA004

1

110112

1

D4021-5

Manufactured No

100

Each

25.0000

2

2

DAS
32
9-89

D4021-5

Blanking Plate

**

14-7-8

Location

Loc Qty

Loc Code

ST083

25

103829

5

115895

20

118895

July-03-14 10:02:52 AM

Shop Packet Print

Page 4

Picklist Print

July-03-14 10:02:52 AM

Page 5

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

1,027.137

33

33

M304FX0 75-16F

Expanded Metal Flat SS

**

M129164 → 33 sf 14.7.8

Location

Loc Qty

Loc Code

WA004

1027.137

M126899

33

M127024

126.74

M127403

123.347

M128082

39

M128447

65.05

M129164

640

DAS

43

9-89

D4020-11

Manufactured

No

100

Each

4.0000

2

2

D4020-11

End Mesh, Basket

**

B112910 → 2v 14.7.8

Location

Loc Qty

Loc Code

WA004

4

116837

4

DAS

43

3-89

D4016-1

Manufactured

No

100

Each

68.0000

3

3

D4016-1

Hinge Half, Base

**

B115903 → 3x 14.7.8

Location

Loc Qty

Loc Code

WA004

68

115903

17

116749

51

DAS

43

9-89

D2931

Manufactured

No

150

Each

1,908.000

2

2

D2931

Bumper

**

DAS

32

9-89

14/7/21 @

Location

Loc Qty

Loc Code

ST013

1908

46064

2

86435

1906

86435

July-03-14 10:02:53 AM

Shop Packet Print

Page 5

Picklist Print

July-03-14 10:02:53 AM

Page 6

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 176.0000 2 2

D2581

Mounting Bracket

**

B 117900 → 2x

DAS

43

9-89

14-7-8

Location

Loc Qty

Loc Code

WA 92

117900 92

WA004 84

102265 84

AN3-10A Purchased No 150 Each 410.0000 6 6

AN3-10A

Bolt

**

DAS

32

9-89

Location

Loc Qty

Loc Code

ST351 110

m127817 35

m128403 75

ST511 300

m128813 150

m128936 150

MS20600-AD4W3 Purchased No 150 Each 355.0000 2 2

MS20600-AD4W3

Cherry Rivets

**

DAS

32

9-89

14/7/21

Location

Loc Qty

Loc Code

ST 348

m129278 348

WA003 7

m127476 7

m 129278

July-03-14 10:02:53 AM

Shop Packet Print

Page 6

Picklist Print

July-03-14 10:02:53 AM

Page 7

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

5,408.000

6

6

DAS

MS21042L3

32

9-89

Nut

Location

Loc Qty

Loc Code

ST307

5408

115835

12

123900

955

M126333

10

M127410

13

M127831

41

M128401

48

M128754

4329

M128107

NAS1149DN832J

Purchased

No

150

Each

3,221.000

2

2

NAS1149DN832J

DAS

32

9-89

Washer

Location

Loc Qty

Loc Code

ST277

3221

M128948

265

124555

145

M126319

11

M127255

516

M128429

984

M129499

1000

M129541

300

M128948

M1289

14/12/21 ①

Picklist Print

July-03-14 10:02:53 AM

Page 8

Work Order ID: 105017

105017

Parent Item: D4785-041

D4785-041

Parent Item Name: Long Basket Base Assembly, LH/RH

Start Date: 7/18/13

Required Date: 7/23/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

4,380.000

12

12

DAS

NAS1149F0332P

32
9.89

14/7/21

Washer

Location

Loc Qty

Loc Code

ST275

4380

122063

205

123900

12

125646

111

m123185

47

m127831

2500

m128401

1205

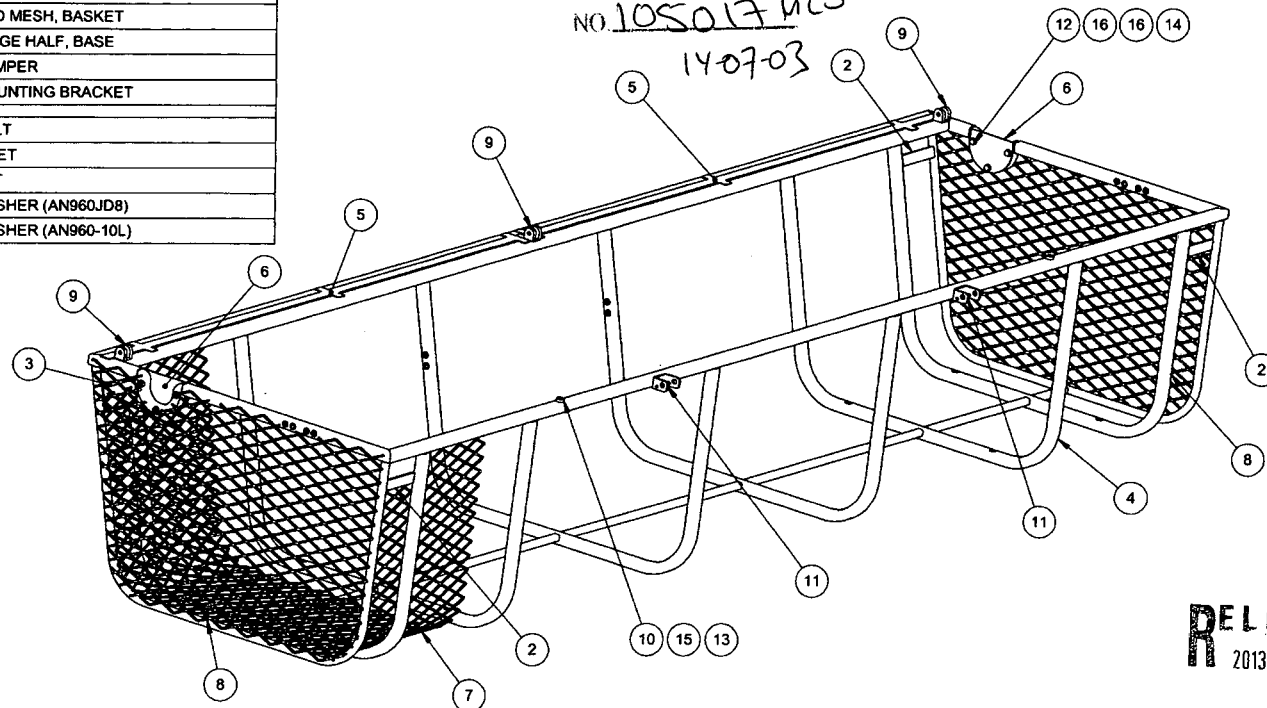
m129541

300

m128401

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4785-041	LONG BASKET BASE ASSY, LH/RH
2	3	D4793-1	HANDLE PLATE
3	1	D4793-3	WIDE HANDLE PLATE
4	1	D4785-101	TUBULAR ASSEMBLY, LH/RH
5	2	D4672-1	BLANKING PLATE
6	2	D4021-5	BLANKING PLATE
7	1	D4020-1	MESH BASKET LONG, BASE
8	2	D4020-11	END MESH, BASKET
9	3	D4016-1	HINGE HALF, BASE
10	2	D2931	BUMPER
11	2	D2581	MOUNTING BRACKET
12	6	AN3-10A	BOLT
13	2	MS20600AD4W3	RIVET
14	6	MS21042L3	NUT
15	2	NAS1149DN832J	WASHER (AN960JD8)
16	12	NAS1149F0332P	WASHER (AN960-10L)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 105017 MJS
140703



D4785-041 LONG BASKET BASE ASSY, LH/RH

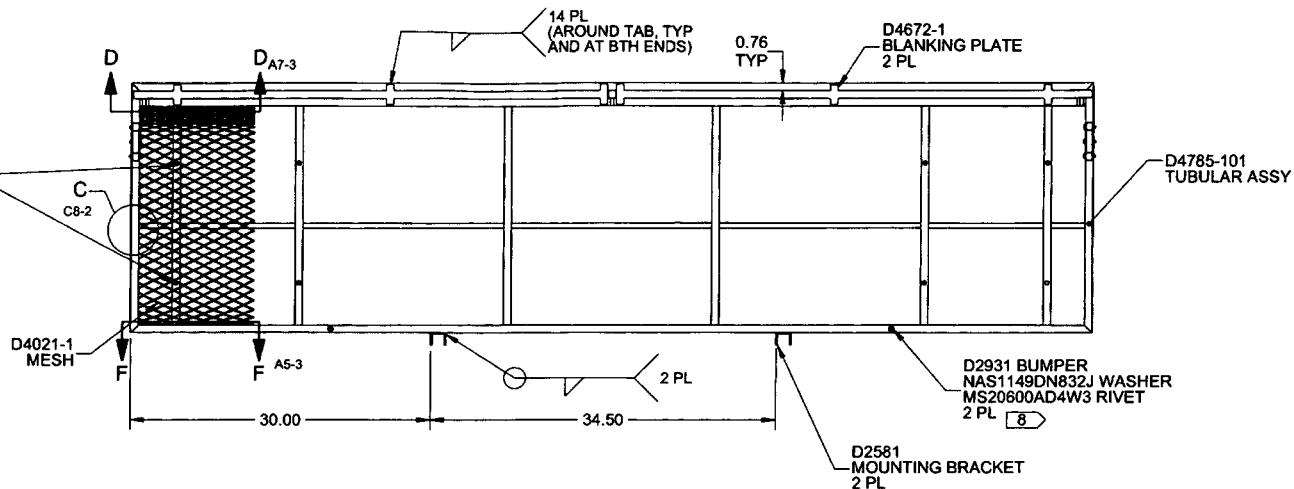
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 50.42 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

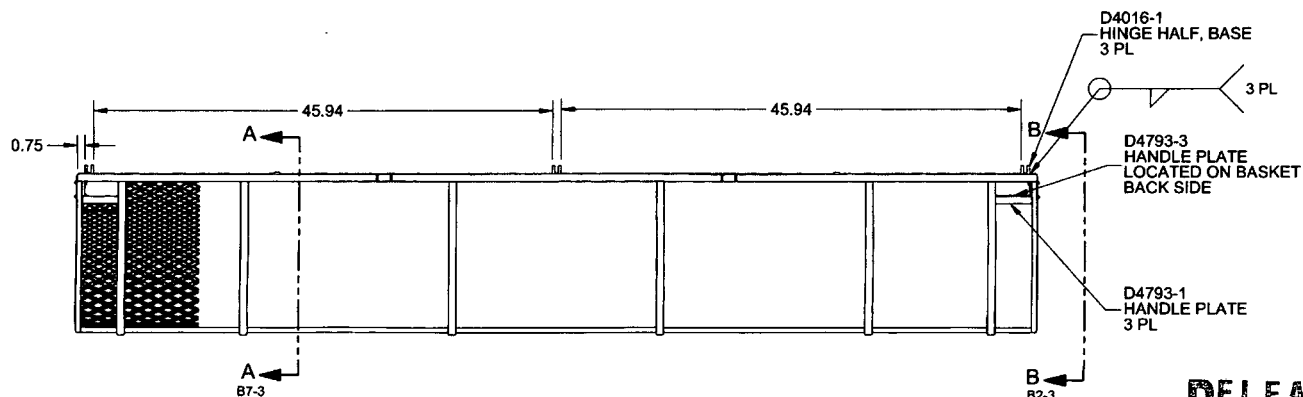
RELEASED
2013-06-20

B	REPLACE D3916-5 WITH D4785-117 (ZN B5-4, B4-4, B5-7); REVISE D4785-5 DIMENSION (ZN B5-5)	RF	13.06.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. B
MFG. APPR.	DC	D4785	SHEET 1 OF 7
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TRIM MESH LOCALLY
Ø 0.50 - Ø 0.60
TO CLEAR BUSHINGS
TYP



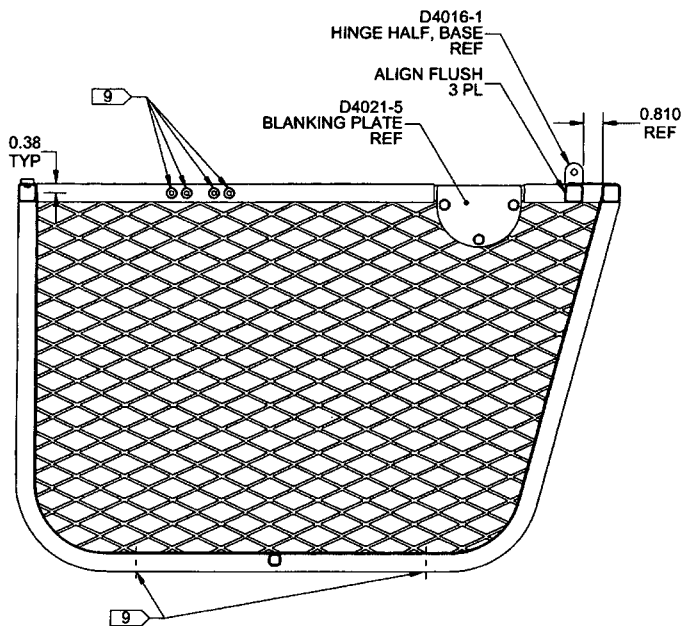
DETAIL C D7-2



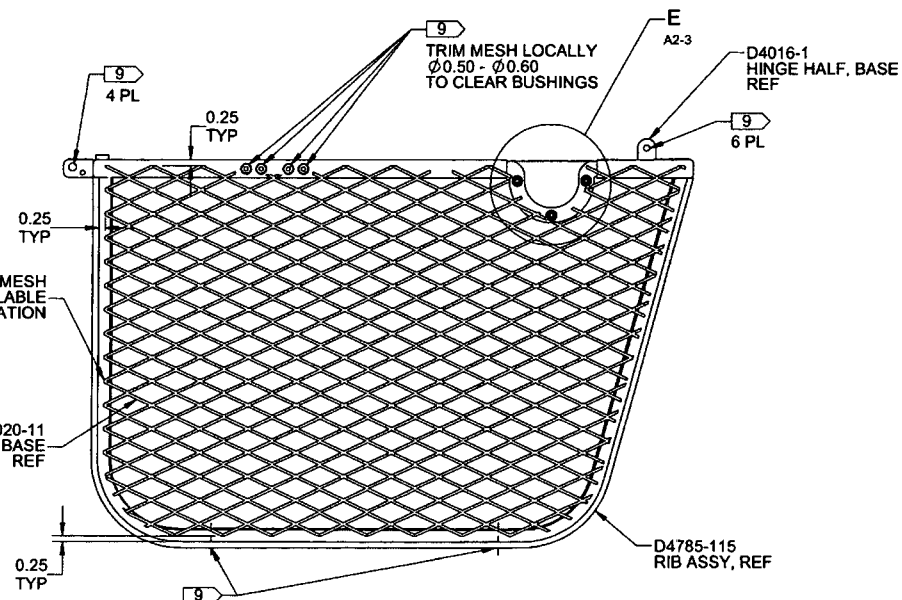
D4785-041 LONG BASKET BASE ASSY, LH/RH
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-06-20

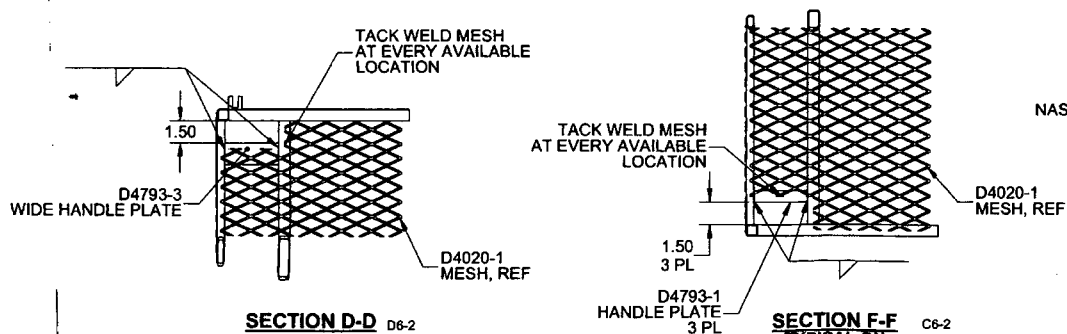
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>N</i>	D4785	SHEET 2 OF 7
APPROVED	<i>#</i>	TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.06.11	<small> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	



SECTION A-A 87-2

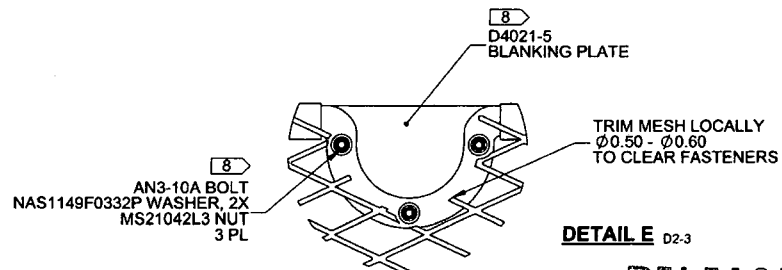


SECTION VIEW B-B A2-2



SECTION D-D D6-2

SECTION F-F C6-2
TYPICAL ON 3 PL

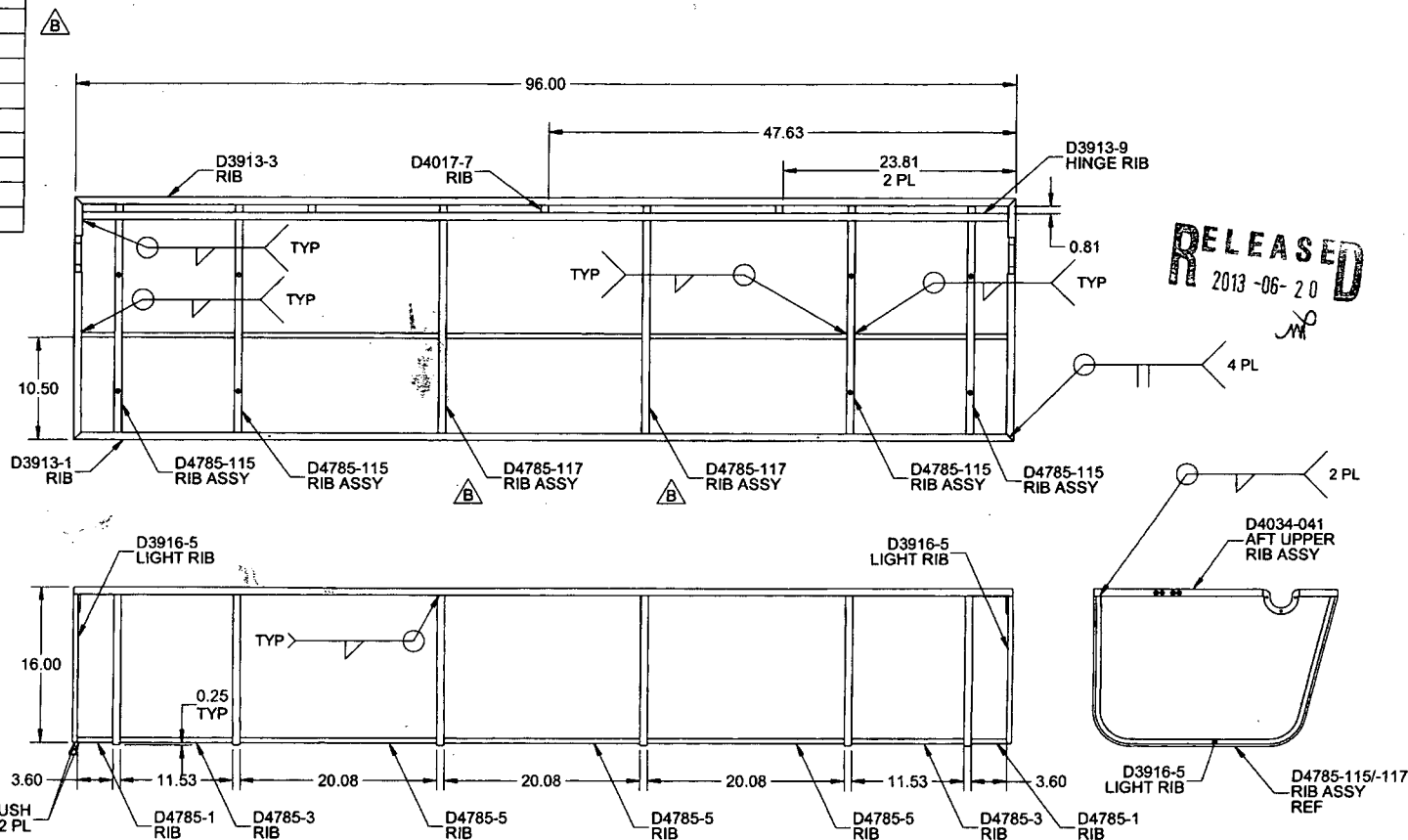


DETAIL E D2-3

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4785	REV. B
MFG. APPR.	DC	SHEET 3 OF 7	
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

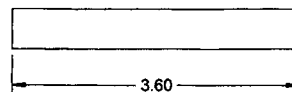
ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4785-101	TUBULAR ASSEMBLY
2	2	D4785-1	RIB
3	3	D4785-5	RIB
4	4	D4785-115	RIB ASSEMBLY
5	2	D4785-117	RIB ASSEMBLY
6	2	D4785-3	RIB
7	3	D4017-7	RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY
10	2	D3916-5	RIB, LIGHT
11	1	D3913-1	RIB
12	1	D3913-3	RIB
13	1	D3913-9	HINGE RIB



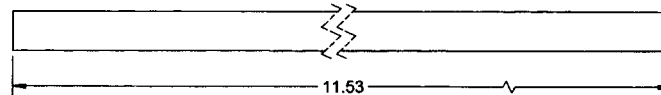
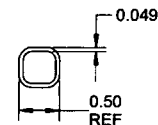
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 28.65 lbs
 - 8) WELD PER DART QSI 004

D4785-101 TUBULAR ASSEMBLY, LH/RH

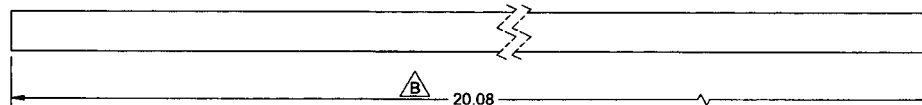
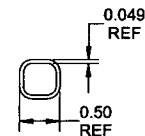
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4785	SHEET 4 OF 7
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



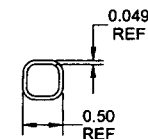
D4785-1 RIB



D4785-3 RIB



D4785-5 RIB



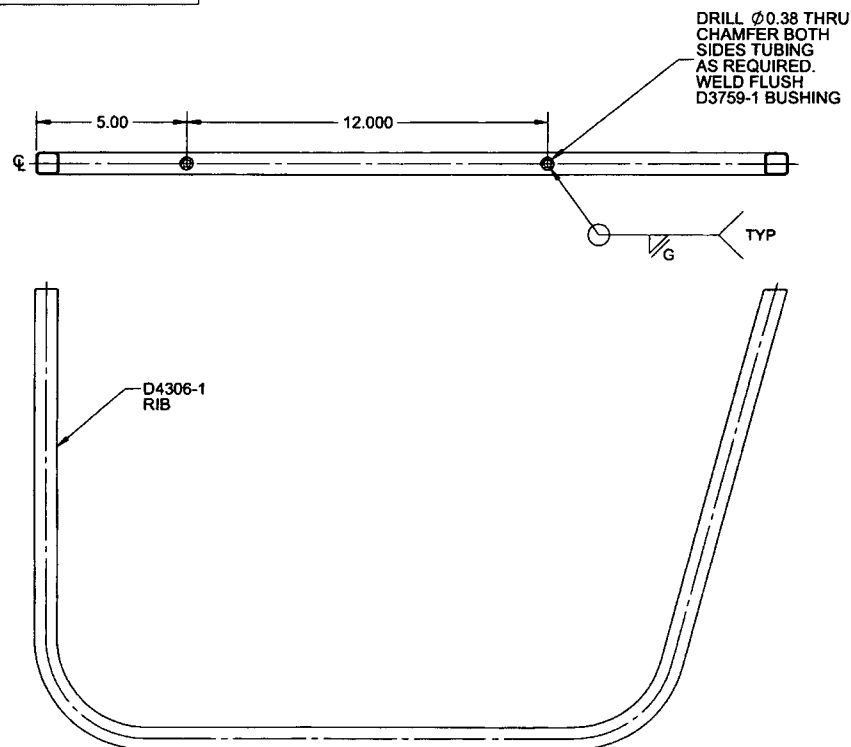
NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
PER ASTM A554 OR ASTM A269 MILL FINISH
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
2013-06-20
WT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. B
MFG. APPR.	JS	D4785	SHEET 5 OF 7
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR TOPIC OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM NO.	QTY. -115	PART NUMBER	DESCRIPTION
1	X	D4785-115	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D3759-1	BUSHING



D4785-115 RIB ASSEMBLY
MAKE FROM D4306-1 RIB

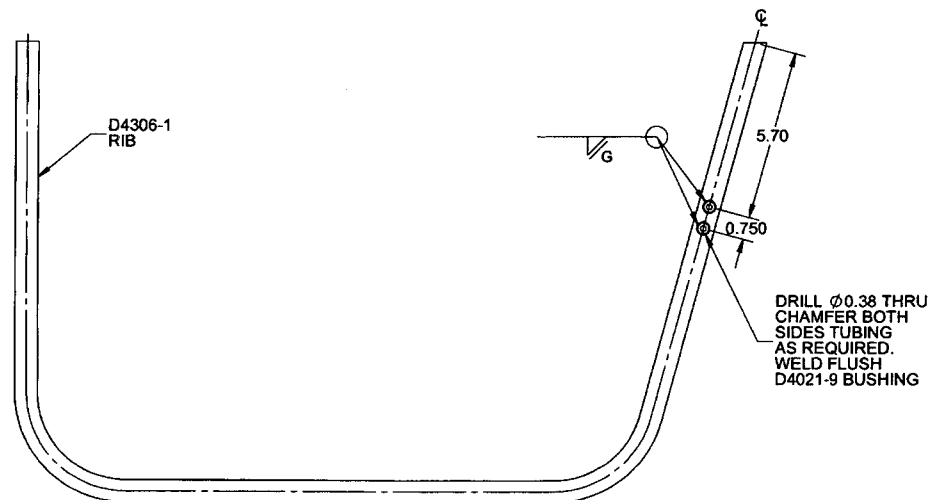
NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.80 lbs
- 8) WELD PER DART QSI 004

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO. D4785	REV. B
MFG. APPR.	SC	SHEET 6 OF 7	
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET BASE ASSY	NTS
DATE	13.06.11	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

RELEASED
2013-06-20
JND

ITEM NO.	QTY. -117	PART NUMBER	DESCRIPTION
1	X	D4785-117	RIB ASSEMBLY
2	1	D4306-1	RIB
3	2	D4021-9	BUSHING







D4785-117 RIB ASSEMBLY 
MAKE FROM D4306-1 RIB

NOTES:

- 1) MATERIAL: D4306-1 RIB
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.81 lbs
- 8) WELD PER DART QSI 004

RELEASED
2013-06-20

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4785	REV. B
MFG. APPR.		SHEET 7 OF 7	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY	NTS
DATE	13.06.11	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	